

Date: Thursday, 28/05/2009 11:33:57 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CROSSBOLT SPACER
Job Number : 48272	
Estimate Number : 10993	
P.O. Number :	Part Number : D2579
This Issue : 28/05/2009 S.O. No. :	Drawing Number : D2579 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 47797	Material :
Written By :	Due Date : 04/06/2009 Qty: 50 Um: Each
Checked & Approved By : <u>JUD 09.05.28</u>	
Comment : Est E 02.06.17 Now turned on Cobra NG est F 07.07.06 rev E dwg EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0500W058	6061-T6 RD Tube .500 x.058W
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Comment: Qty.: 0.3762 f(s)/Unit Total : 18.8108 f(s)
 6061-T6 Tube .500 x.058W
 Material: 6061-T6 (WW-T-700/6) or 5052-H32 (WW-T-700/4)
 0.500 Dia x 0.058 Wall Batch M111757

09.06.01
09.05.31

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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**Comment:** HARDINGE CNC LATHE SMALL

- 1- Machine as per Folio FA245.
- 2- Buff ends to remove oxidization.

09.06.01

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

09.06.01
(54)

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

09/06/02
(54)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock
 Location: BARCLAY

09/06/02
(54)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: CROSSBOLT SPACER

Job Number: 48272

Part Number: D2579

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/02 ME

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



ME
09-06-02

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

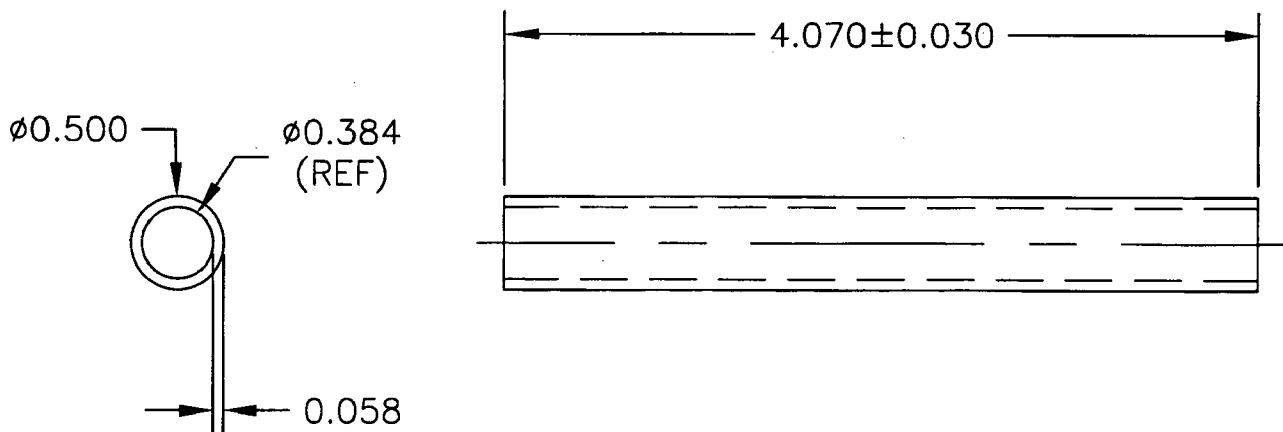
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN <i>HA</i>	DRAWN BY <i>RA</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HA</i>	APPROVED <i>HA</i>	DRAWING NO. D2579	REV. E SHEET 1 OF 1
DATE 07.04.17		TITLE CROSS BOLT SPACER	SCALE 1:1
A	96.09.16	NEW ISSUE	
B	96.12.05	0.065 WALL WAS 0.035 WALL	
C	97.02.21	0.058 WALL WAS 0.065 WALL	
D	99.05.19	4.070 LENGTH WAS 4.100 (TSR A1095)	
E	07.04.17	UPDATE NOTES	

RELEASED
07.06.28**D2579 CROSS BOLT SPACER****D2579 CROSS BOLT SPACER**

- 1) MATERIAL: 6061-T6 TUBING PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061T6T0500W058)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENTS
WITHOUT NOTICE
WORK ORDER NO. 48212

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